Work	\sim	•	TT	703	\sim
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VVIII				/ 11.74	ъ.т



Page 1

Monday, June 06, 2011 10:02:34 AM

Item ID: **Revision ID:** D3535-33

Wearshoe

Item Name: **Start Date:**

6/7/2011

QC:

Start Qty: 6.00 Required Date: 6/21/2011

Req'd Qty: 6.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: ______

Operation

Description

Date: |-06-06 Tooling:

Date:

Accept

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Accept Qty Code

Reject Qty

B11-6-7

Run

Setup Start

Stop

Start

Stop

Reject Number Stamp

Insp.

Draw Nbr

Revision Nbr

D3535

Sequence ID/

Work Center ID

Rev B

100

Waterjet

FLOW CNC Waterjet

عمد , ملان

FLOW WATER JET

Memo

Deburr if necessary

□Prog Rev: B □2-

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00 ~

0.00

18 (1-6-7

120

QC8- Inspect parts - second check

Memo

Memo

Quality Control

-4	Puo								
W/O:			WO	RK ORDER CHANGE	ES .				
DATE	STEP	PROC	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			•					. 	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE (NCR)	,		
		Description of NC	Corrective Action Sect			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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·									

Required Date: 6/21/2011

Work Order II	70383
Monday, June 06, 201.	1 10:02:35 AM

Page 2

Item ID:

D3535-33

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Wearshoe

6/7/2011

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

Start

Stop



OC:

Date: _____ SPC (Y/N):

Date:

Tool # Plan Accept Qty

Code

Reject Qty

Run

Reject Insp. Number Stamp

130

Brake NC

Sequence ID/

Work Center ID

NC BRAKE

Operation

Description

Memo

0.00

0.00

Set Up/

Run Hours

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326.

□2-

Identify as D3535-33.

140 .

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

150

Powdercoat

Powder Coating

M115128

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

8×9 m/11/06/pg

W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	By Date Qt				
							·		
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No - DQ	A:	Date: _	
	Re	esolution:	Disposition	Disposition: QA: N/C Closed:					
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCR	3)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation Approval App		Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
								-	

Work Order ID 70383

Monday, June 06, 2011 10:02:35 AM



Page 3

Item ID:

D3535-33

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearshoe

Start Date: 6/7/2011 Required Date: 6/21/2011

Start Qty: 6.00

Reg'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

A	pprovals:	
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Process Plan:

Operation

Description

Date:

Tooling:

Date:

Tool ID

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop



Sequence ID/ Work Center ID

160

Memo

QC3-Inspect Part Finish

0.00

0.00

Set Up/

Run Hours

Accept

Qty

Reject Qty

Reject Insp. Number

Stamp BL 11-6-9.

Quality Control

Memo

Identify as per dwg & Stock Location

0.00

Packaging

Packaging

180

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

M6 19 99) MF 11-06-09

Dart	Aero	space	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date: _	
	Resolution: Disposition: QA: N/C (_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	₹)			
DATE	OTED	Description of NC			ion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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	,								

Picklist Print

Monday, June 06, 2011 10:02:30 AM

Work Order ID: 70383

Parent Item:

D3535-33

Parent Item Name: Wearshoe



Start Date: 6/7/2011

Required Date: 6/21/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No		. 100	sf	266.3814	0.6445	4.070526	56	2	· · · · · · · · · · · · · · · · · · ·

1. 1

304/316 .040 Sheet

Location	Loc Oty	Loc Code
MAT020	266.3814	***************************************
116623	0.2	
117550	10.1814	***************************************
117933	256	117833

W/O:		***************************************	WO	RK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	art No: PAR #: Fault Category: NCR:					R: Yes	No DQ	A :	Date:	
	Re	esolution:	Disposition: QA: N/C Closed:					ed: Date:		
NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCR)	ı		
DATE	STEP	Description of NC	Initial	Corrective Action Se Action Description	ection B	Sign &		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Secti	ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	76383
Description: Wearshoe	Part Number:	D3535-33
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First	Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	,191	>		U BUT	
0.300	+/-0.010	,303	2		ν	
0.300	+/-0.010	.305	×		V	
1.885	+/-0.010	1,890	+		V	<u>.</u> .
2.000	+/-0.010	7,000	8		V	
6.000	+/-0.010	6.00	_		7 1801	· · · · ·
9.500	+/-0.010	9,500	V		7	,
15.250	+/-0.010	(5.750	x		τ	
21.000	+/-0.010	21.000	X.		τ	
24.500	+/-0.010	34.500	8		7	
6.00	+/-0.030	6.00	>		7	
6.75	+/-0.030	6.75	8		7	
13.50	+/-0.030	13,50	8		7	
0.040	+/-0.010	,036	&		v	
						W sha .
						41.14.4

Measured by:	B	Audited by:	Prototype Approval:	N/A	
Date:	11-6-7	Date: U66/05	Date:	N/A	
				* *	

Ĺ	Rev	Date	Change	Revised ,by	Approved
	Α	09.10.16	New Issue	KJ KJ	TT.
				17/	

	Oopaoo								
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				**					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
Resolution:		solution:	Disposition: Q/			A: N/C Closed: Date:			
NCR:		. *. . *.	WORK ORDE	ER NON-CONFORMAN	ICE (NC	R)	í		>
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	B Sign		cation on C	Approval Chief Eng	Approval QC Inspector
		Occitor A	Chief Eng	Chief Eng	Date	9		Office Eng	GO MISPECTO
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CHECKED

APPROVED

DRAWING NO.

SHEET

SCALE 읶

1:10

REV.

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DART

AEROSPACE PORT HADLOCK,

USA,

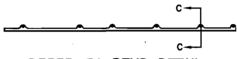
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07.04.17

WEARSHOE

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RELEAS



D3535-31 BEND DETAIL

24.500 ————
21.000
15.250 ———
9.500
2.000
6.00 6.75 DETAIL A
1.885 — 13.50 — Ø0.188 (TYP 3 PLS)
DZEZE ZZE ELAT DATTEDNI



1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 CAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES TO 0.010 MAX IDENTIFY WITH DART P/N USING WHITE FINE POINT

PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

D3535-33F FLAT PATTERN D3535-33 BEND DETAIL

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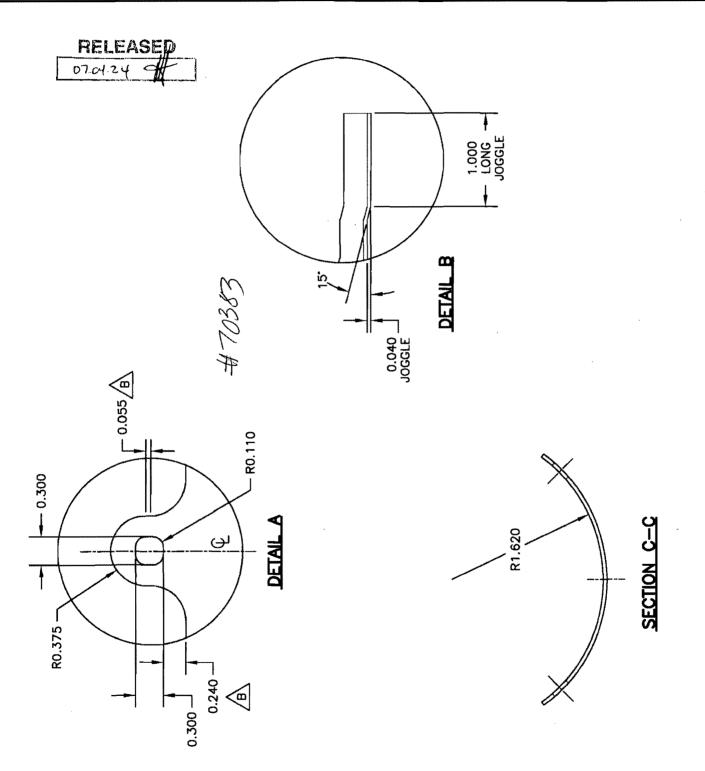
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DESIGN B	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED XA	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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W/O:			ES						
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:		PAR #:	Fault Category: NC			NCR: Yes No DQA: _			·
Resolution:		Disposition	_ QA: N/C CI	QA: N/C Closed: Date:					
NCR:			WORK ORD	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		Sign 8	Verific Secti		Approval Chief Eng	Approval QC Inspector
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